

Work Order ID 83192

April-13-12 1:01:39 PM

Item ID: D412-698-012

Revision ID:

Item Name: Cabin Door Roller, RH

Start Date: 13/04/2012 Start Qty: 2.00

Required Date: 27/04/2012 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *MLO*

Date: 12/04/13 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

*DAS
16
2-08-13**12/04/13**MLO 12/08/10*

110

110

Packaging

Packaging

Pick Kit

0.00

*802**12/08/10 JB*

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

*DAS
16
2-08-13**12/04/13**1*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 83192

April-13-12 1:01:39 PM

83192

Page 2

Item ID: D412-698-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cabin Door Roller, RH

Stop

NS2

Start Date: 13/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

0.00

2X

SP
128-29

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-012
Location: 623

Rev B

140

QC21- Final Inspection - Work Order Release

0.00

MLJ 12/08/130

140

Memo

0.00

ML
12-08-29

QC

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-13-12 1:01:43 PM

Page 1

Work Order ID: 83192

83192

Parent Item: D412-698-012

D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 13/04/2012

Required Date: 27/04/2012

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Start Qty: 2.00

Required Qty: 2.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Picklist Print

April-13-12 1:01:43 PM

Page 2

Work Order ID: 83192

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

83192
D412-698-012

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3183-044

Manufactured No 110 Each 2.0000

** 2 B. 85996 Sp.

D3183-044

Bracket Assembly

Location	Loc Qty	Loc Code
ST	-4	
ST235B	6	
75034	2	

D3199-1

Manufactured No 110 Each 12.0000

** 9 18 83267 23 8

D3199-1

Bracket

Location	Loc Qty	Loc Code
ST236	17	
78618	4	
79797	8	
ST236A	-5	

D3202-1

Manufactured No 110 Each 8.0000

** 0 2 82663 23 81208/10

D3202-1

Cover

Location	Loc Qty	Loc Code
ST241A	8	
70294	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	/ 3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
1	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9			9		D3199-1	BRACKET
1	7	1		1		D3202-1	COVER
			4			D3203-1	HANDLE
			1			D3220-041	DOUBLER
			1			D3220-042	DOUBLER
			2			D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
				8		AN960JD416L	WASHER
				8		MS21042L4	NUT (OR MS21042-4)
				16		MS24694-S98	SCREW
					1	MS24694-S101	SCREW

